

Work Order ID 163372

163372

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Tuesday, June 27, 2017 11:34:06 AM

Item ID: D4770-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar Weldment
 Start Date: 6/29/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 7/10/2017 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: DAS Date: JUL 03 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4770	C								

100 0.00
 100
 Cold Saw Memo 0.20
 Hyd Mech 1- CUT D4770-1 BLANKS AT 22.0"

4 Q.L 17-07-10

110 Weld per dwg & QSI004 4.5 0.00
 110
 Autoweld 1 Memo 1.20
 Automated Welding 1 ***SEE NOTE 8 FOR SURFACE BUILDUP***
 1- USE GRINDER TO CHAMFER END AS PER DWG .
 FOR AUTOMATED WELDING USE 8259 HARDCOAT
 BATCH: M137216

4 Q.L 17-08-11

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.40							
Quality Control									

u 8/15/17

DAS
21
9-89

DAS
21
9-89

AUG 21 2017

Picklist Print

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Work Order ID: 163372

163372

Parent Item: D4770-041

D4770-041

Parent Item Name: Bar Weldment

Start Date: 6/29/2017

Required Date: 7/10/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 17.04.17 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	126.5780	1.85	7.789474			
M304B0 250x0 500									**				
304 BAR .250 x .500													

Q.L 17-07-10

Location

WA002

Loc Qty

126.578

Loc Code

m137512

22.57

m137065

13.2

m137172

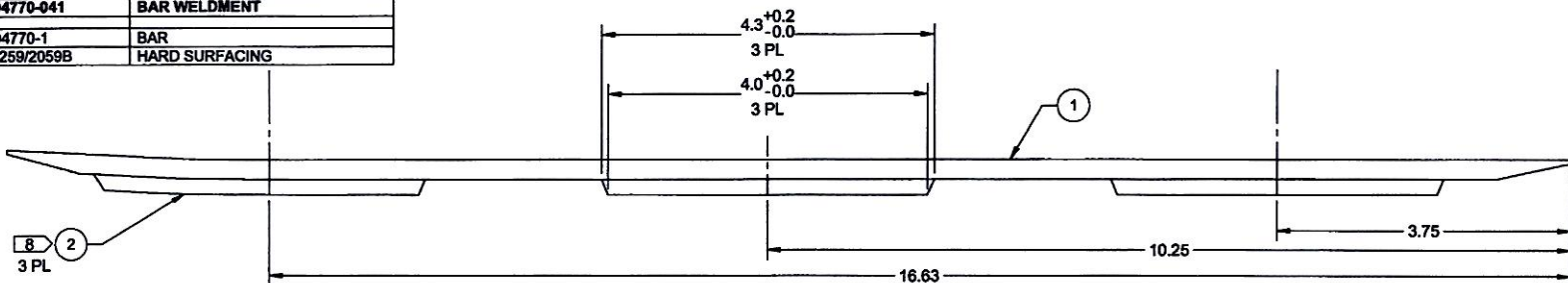
6.808

m137824

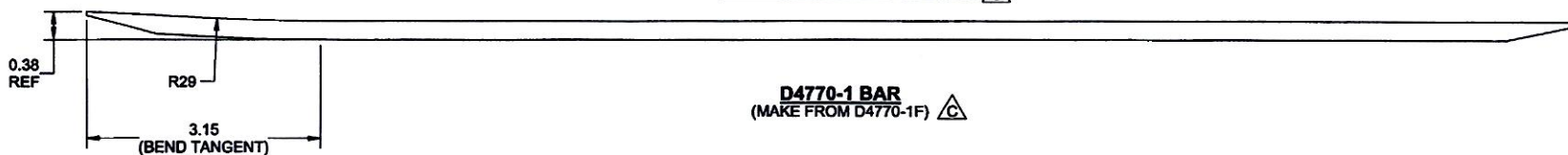
84

480
~~777~~ 5,85
118

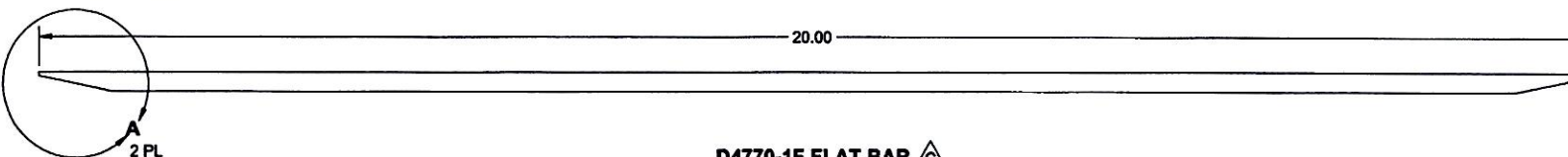
ITEM	QTY	P/N	DESCRIPTION
	X	D4770-041	BAR WELDMENT
1	1	D4770-1	BAR
2	A/R	8259/2059B	HARD SURFACING



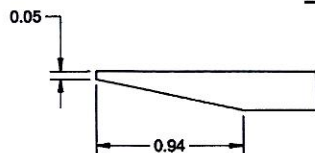
D4770-041 BAR WELDMENT



D4770-1 BAR
(MAKE FROM D4770-1F)



D4770-1F FLAT BAR



DETAIL A
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *163372 MLS*
120704

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.02 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED

2017 APR 10
EN 17-35Z

C	ADD -041/-043/-045/-047 WELDMENTS, REMOVE NOTCHES FROM ALL BARS, ADD WELD NOTE 8, DELETE SH 5 REASON: NEW WELD PROCESS	SAD	17.02.14
B	ADDED BEND TO D4770-1 BAR, MINOR DIM CHANGES TO D4770-3 BAR, ADDED SHT 3 AND SHT 5, ADDED D4770-7 BAR	AP	15.04.01
A	NEW RELEASE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	SAD		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4770	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BAR	NTS
DATE	17.02.14	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED